

Work Order ID 74025

Tuesday, September 20, 2011 1:08:42 PM



Page 1

Item ID:	D3213-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Assembly					
Start Date:	9/20/2011	Start Qty:	8.00		Cust Item ID:	
Required Date:	10/3/2011	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-09-26	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3213	B								

100
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520
 Identify as D3213-041

EP 12/02/02 (8)

110
 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

8/2/02/02

(78)

120
 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00
 Powdercoat Memo 0.00
 Powder Coating

START TIME: 10:00
 FINISH TIME: 10:30
 3200F

8xØ m-f 12/02/03

m 115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:						
Item Name:	Door Assembly				Stop	
Start Date:	9/20/2011	Start Qty:	8.00			
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Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>8. BK 12-23.</u>
140 Small Fab Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3213	0.00 0.00							<u>EP 12/02/06 (8)</u>
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>(X)</u>

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Item ID: D3213-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 9/20/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location:

ST 211

0.00



Packaging

Memo

0.00

Packaging

(8X) SP 12-02-06.

170

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ULS 12/02/06
MF
12-02-06

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Picklist Print

Tuesday, September 20, 2011 1:08:47 PM

Page 1

Work Order ID: 74025

Parent Item: D3213-041

Parent Item Name: Door Assembly



Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-3 Hinge 15.0"		Manufactured	No			100	Each	4.0000	2	16		9/12/02/02	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST037			4						
				68895			4						
D3213-1 Door Panel		Manufactured	No			100	Each	4.0000	1	8		9/12/02/02	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST232B			4						
				68906			4						
D3213-3 Door Panel		Manufactured	No			100	Each	6.0000	1	8		9/12/02/02	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST232B			6						
				68907			6						
MS20470AD4-6 Rivet, Universal Head		Purchased	No			100	Each	2,704.000	1	8		9/12/02/06	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST319			2704						
				117395			32						
				117887			1157						
				118927			1515						

B74028 (GX)
B74504 (10x)

B74026 (8x)

B74539 (8x)

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 1:08:48 PM

Page 2

Work Order ID: 74025

Parent Item: D3213-041

Parent Item Name: Door Assembly

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 8.00

Required Qty: 8.00

D2137

Manufactured No

140

Each

14.0000

1

8



Decal - No Step

Location

Loc Qty

Loc Code

ST006

14

72053

14

D2419

Manufactured No

140

Each

4.0000

1

8



Handle

Location

Loc Qty

Loc Code

GA

4

69732

4

D2462

Manufactured No

140

f

455.8674

2.4

19.2



Seal

Location

Loc Qty

Loc Code

ST404

455.8674

48530

455.8674

D2728-1

Manufactured No

140

Each

0.0000

0

0



Dart Logo label

MS20470AD4-4

Purchased No

140

Each

3,390.000

24

192



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST139

78

117423

78

ST319

3312

116188

136

116391

66

118614

3110

Ep 12/02/06
B 76064 (8x)

Ep 12/02/06
B 78994 (8x)

Ep 12/02/06
19.2

Ep 12/02/06
0

Ep 12/02/02
192

M119109
(192x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 3

Tuesday, September 20, 2011 1:08:48 PM

Work Order ID: 74025



Parent Item: D3213-041



Parent Item Name: Door Assembly

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 8.00

Required Qty: 8.00

NAS1149DN632J

Purchased

No

140

Each

892.0000

1

8



Washer

Handwritten signature and date: 9/20/2011

Location

Loc Qty

Loc Code

ST297

892

118428

892

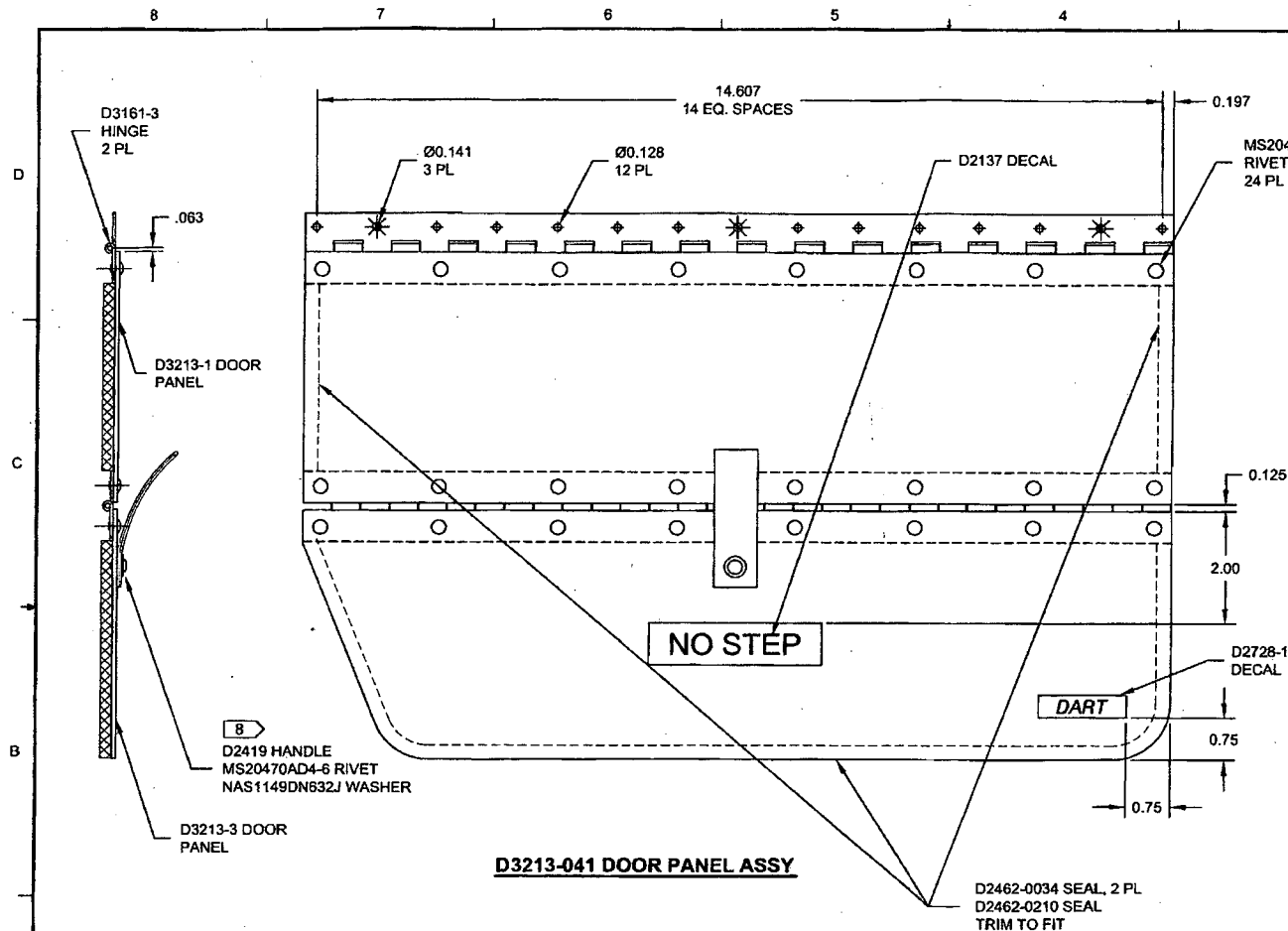
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



QTY -041	PART NUMBER	DESCRIPTION
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74025

RELEASED
2011-06-14

B	FORMAT TO CURRENT STD; ADD D3213-041B REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>MB</i>		
APPROVED	<i>MB</i>		
DE APPR.	<i>MB</i>		
DATE	11.06.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3213
REV. B
SHEET 1 OF 4
TITLE DOOR ASSEMBLY
SCALE NTS

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D3213-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXXX" PER QSI 044 6.6
- 7) WEIGHT: 1.49 lbs
- 8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

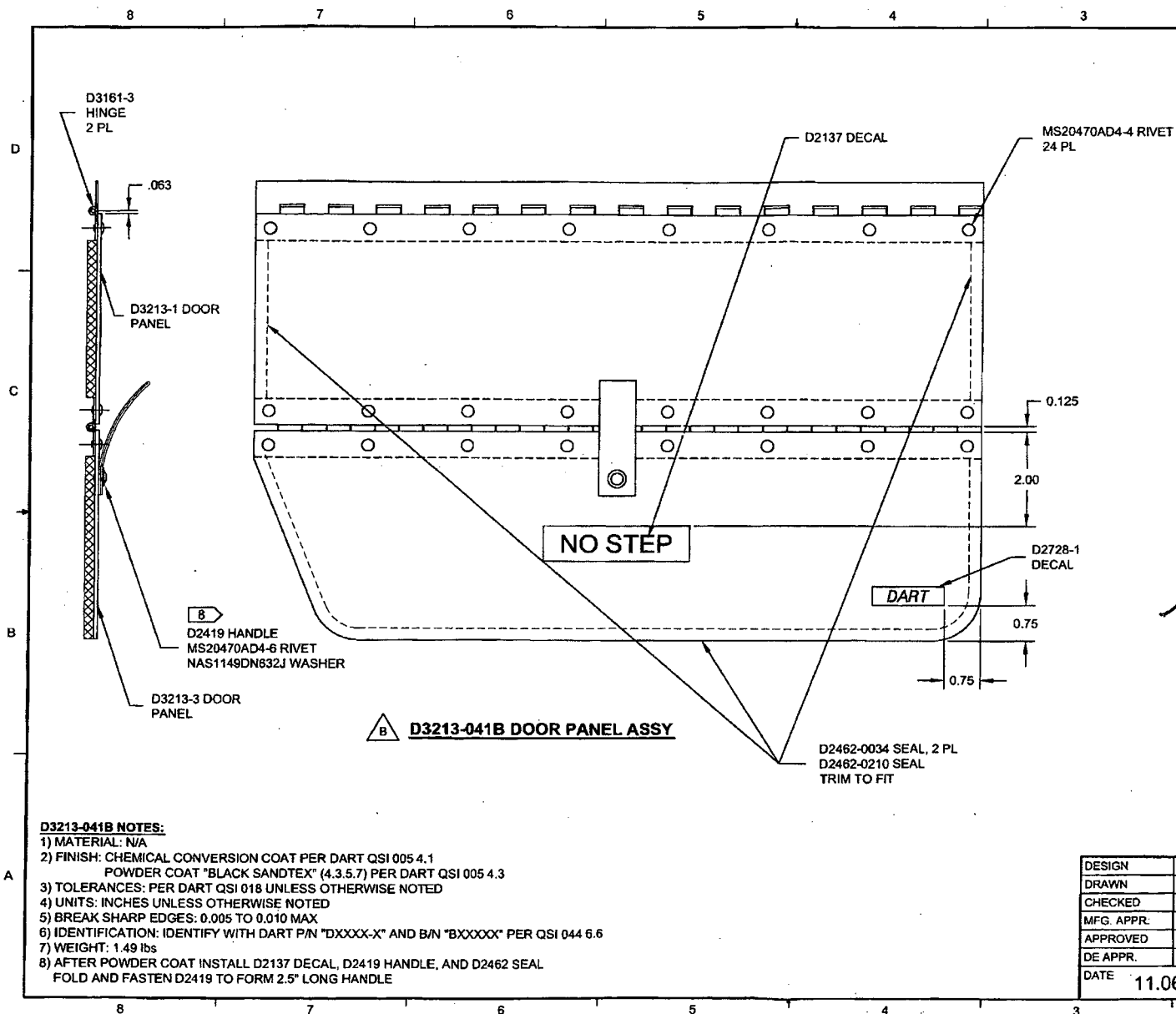
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



QTY -041B	PART NUMBER	DESCRIPTION
X	D3213-041B	DOOR ASSEMBLY, BLANK
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

14025

RELEASED
2011-06-14

D3213-041B NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.6
- 7) WEIGHT: 1.49 lbs
- 8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	GP	DRAWING NO. D3213	REV. B
MFG APPR.	GP	SHEET 2 OF 4	
APPROVED	GP	TITLE DOOR ASSEMBLY	SCALE NTS
DE APPR.	GP	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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74025

RELEASED
2011-06-14

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.003

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.42 lbs

DESIGN	<i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3213 TITLE DOOR ASSEMBLY SCALE NT
DRAWN	<i>JP</i>	
CHECKED	<i>JP</i>	
MFG. APPR.	<i>JP</i>	
APPROVED	<i>JP</i>	
DE APPR.	<i>JP</i>	
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